

Work Order ID 130618

Tuesday, March 17, 2015 2:16:34 PM

130618

Page 1

Item ID: D2596

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Web, 205 Skidtube

Stop ***NS2***

Start Date: 3/17/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/17/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 1503-17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

6 Ø 15-3-18
[Signature]

110

0.00

110

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

6 Ø 15-3-18
[Signature]

120

0.00

120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

15-3-18
[Signature]

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N900040100

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LG002</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15-3-18
(6)

MLJ 15-3-19
LMF
15-3-18

Picklist Print

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Page 1

Work Order ID: 130618

130618

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 3/17/2015

Required Date: 3/17/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	50.0000	1	6			

D2500-3-100

Ext'n -I' Beam Web 4"

15-3-17

Location

HALL

110687

Loc Qty

50

50

Loc Code

6

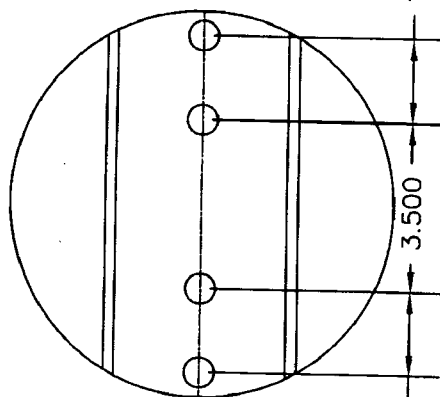


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

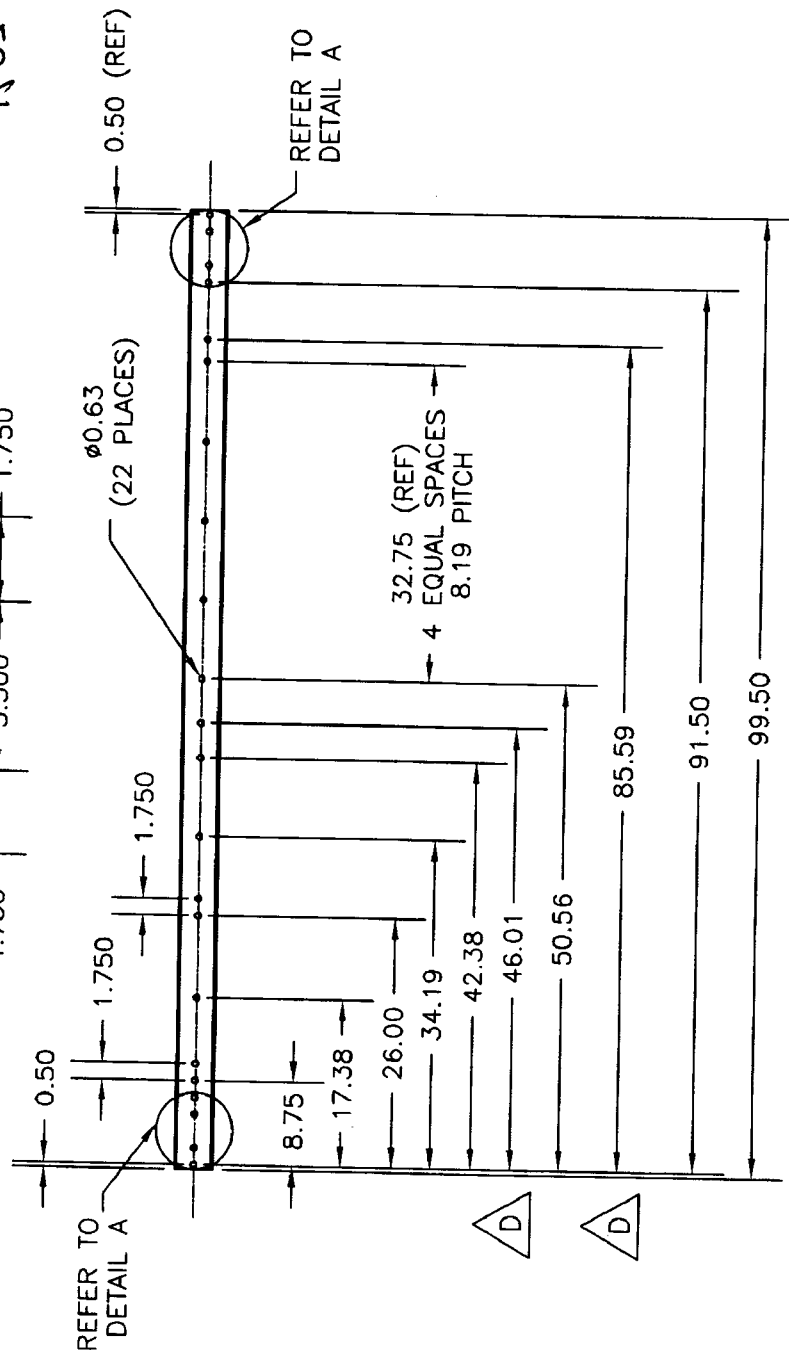
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07.06.28

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130618 MGS
1503-17



DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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